

Date: Friday, 22/05/2009 9:57:12 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : PANEL , POST LH, UPPER
<b>Job Number</b> : 48129	
<b>Estimate Number</b> : 13943	
<b>P.O. Number</b> :	<b>Part Number</b> : D39471
<b>This Issue</b> : 22/05/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3947-1
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : IN0001
<b>First Issue</b> : 22/05/2009 <b>Type</b> : R&D THERMOFORMING	<b>Drawing Revision</b> : A PROTOTYPE 09.05.21
<b>Previous Run</b> :	<b>Material</b> : MLEXS093F600607
<b>Written By</b> :	<b>Due Date</b> : 22/05/2009 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUD 09.05.22</u>	
<b>Comment</b> : Est. Rev. A New Issue 09/05/22 DL	

Additional Product

PROTOTYPE

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MLEXS093F600607	GE PLASTICS LEXAN SHEET
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**Comment:** Qty.: 3.5385 sf(s)/Unit Total : 3.5385 sf(s)  
 GE PLASTICS LEXAN SHEET

M107574

09.05.22

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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**Comment:** HAND FINISHING THERMOFORMING

1) Machine set up

BB 09/05/22

3.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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**Comment:** HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

BB 09/05/22

(X1)

4.0	THERMOFORMING	THERMOFORMING MACHINE
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**Comment:** THERMOFORMING MACHINE

Thermoform as per Dwg. D3947-1 and folio (FTA 3946-1 Prototype ) using tool DT 9483

Dwg. Rev. AFolio Rev. A

BB 09/05/22

(X1)

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

ENGINEERING  
APPROVAL

BB 09/05/22

(X1)

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Drawing Name: PANEL , POST LH, UPPER

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



(81)

Comment: SECOND CHECK

DL 09.05.22

7.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



(71)

Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

DL 09.05.22

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



(X1)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

DL 09.05.22

9.0

QC5

INSPECT WORK TO CURRENT STEP



ENGINEERING  
APPROVAL



Comment: INSPECT WORK TO CURRENT STEP

DL 09.05.22

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

FOR ENGINEERING USE ONLY

N/A ENG USE ONLY

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

DL 09.05.22 Prototype

Job Completion



00280A  
init  
09-06-05

DART AEROSPACE LTD	Work Order: 48129
Description:	Part Number: D 3947-1
Inspection Dwg: D 3947-1 Rev: A	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>      </u> " <i>N/A</i>				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: *BB*

Date: 09/05/22

### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
27.4		27.4	✓			
3.8		3.8	✓			
0.6		0.6	✓			
0.4		0.4	✓			
1.0		1.0	✓			
0.065		0.073	✓			
0.080		0.088	✓			

Measured by: *DL*

Date: 09.05.22

Audited by: *BB*

Date: 09/05/22

Prototype Approval: *UP*

Date: 09/05/22

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

